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Handwritten: Mary, 5000 M24

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D4379-5
Job Sheet 175500



Part No: D4379-5

Job Qty: 100 ea

Part Name: Wearplate Cup



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/5/18

Job Tracking No:

Due Date: 5/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 14-04-01 JLM VERIFIEWD BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea		5/4/18	0.00	0.00	Start Up Machining-3		<i>18/04/30</i>
100	Doosan	100 pcs		5/7/18	0.02	12.94	Doosan		<i>18/04/30</i>
120	QC	100 pcs		5/7/18	0.00	0.00	QC8		<i>18/05/01</i>
130	Packaging	100 pcs		5/7/18	0.00	0.00	Packaging3-2		<i>18/05/02</i>
140	QC21-SA	100 Ea		5/7/18	0.00	0.00	QC21		<i>18/05/02</i>

Part Op 100 - turn as per Dwg and folio FB300
Descriptions: 130 - LOCATION: WA001

DAS
21
8-88

MAY 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	4.1000 ft (.041 ea)	90-Start up Operation	<i>5012410 x 1.614</i> <i>5018003 x 3.540</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.000	4	47	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	<i>0.870</i>
2	Wearplate Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	<i>0.267</i>
3	Wearplate Cup	0.466Inches ± 0.010	0.476 0.456		<i>0.416</i>
4	Wearplate Cup	0.353Inches ± 0.010	0.363 0.343		<i>0.354</i>
5	Wearplate Cup	0.031Inches ± 0.010	0.041 0.021		<i>0.031</i>
6	Wearplate Cup	45.000Degrees ± 0.500	45.500 44.500	Angle	<i>45</i>
7	Wearplate Cup	0.200Inches ± 0.010	0.210 0.190		<i>0.200</i>
8	Wearplate Cup	0.507Inches ± 0.010	0.517		<i>0.506</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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DART
AEROSPACE

Container No: S067127

Part: D4379-5

Job No: 175500

Serial No/Batch: S067127

Revision:
Inspector:

Date: 04/20/18

UPDATE

Work Order update only ☐

DART
AEROSPACE

AGAINST DEPARTMENT/PROCESS

Cross tube
Small Fab
Finishing
Composite

Water Jet
Prod. Eng. Coord.
Rec/Store/Packaging
Supplier

Engineering
Quality
Other

re :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced
Bending
Centre Not Concentric
Cracks
Crimp/Kink/Ripple/Wave
Cuffs
Crushing
Heat Treat
Wave/Twist in Tube
Marks/Chatter

FAULT CATEGORY

Temperature/Cure
Set-up
BOM/Route
Broken/Damage/Defect
Inspection Incomplete/Unqualified
Contamination
Countersink
Cut Too Short
Instructions Incomplete/Unclear
Drill Holes

Power Loss/Surge
Folio/Program
Grain
Weld
Wrong Stock Pulled
Out of Sequence
Off-set
Mislabeled
Fit/Function
Misaligned/off center

Positioned Wrong
Outside Dimensions
Over/Under tolerance
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Misread
Turning Sequence

OTHER :